

9/20/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBT18520
Job Sheet 201029



Part No: RBT18520

Job Qty: 2 pcs

Part Name: Main Rotor Damper Load Test Device



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/20/19

Job Tracking No:

Due Date: 11/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 19759

Note: DWG RBT18520 Rev Q IPP REV A 18.02.07 NEW ISSUE RQ VERIFIED BY DP/IPP Rev. B 19.02.22 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	11/8/19		0.00	0.67	Small Fab - 1		MLC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
110	QC 5	2 pcs	11/8/19		0.00	0.00	QC 5 - 10		DAS OCT 24 2019 68 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
120	External Load - 2 - B4B	2 pcs	11/8/19		0.00	2.00	External Load - 1 - B4B		N/R
							External Load - 2 - B4B		
							External Load - 3 - B4B		



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CANADA
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Container No: S225896



Part: RBT18520

Job No: 201029

Serial No/Batch: S225896

Revision: Q

Inspector:

Exp Date:

Instructions:

Date: 10/24/19

DAS
03
9-89

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9/20/2019

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125 QC 5

2 pcs

11/8/19

0.00 0.00

QC 5 - 10

QC 5 - 12

QC 5 - 17

QC 5 - 18

QC 5 - 19

QC 5 - 22

QC 5 - 24

QC 5 - 3

QC 5 - 43

QC 5 - 49

QC 5 - 51

QC 5 - 58

QC 5 - 68

QC 5 - 9

QC 5 - 50

QC 5 - 30

QC 5 - 40

QC 5 - 61

QC 5 - 81

130 Packaging 3-1 - Stock - B4B 2 pcs

11/8/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

140 QC 21 - FG

2 pcs

11/8/19

0.00 0.00

QC 21 - FG - 21

QC 21 - FG - 70

QC 21 - SA - 53

Part Op 100 - Assemble as per drawing. See note 2,3,4, and 5.

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Descriptions: **110** - (QC5- Inspect part completeness to step on W/O)
120 - 1-Load test as per drawing sheet 15. 2-Engrave -11 as per drawing sheet 11 note 1 using MARKTRONIC engraver.
125 - QC5- inspect part completeness to step on W/O
130 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
10164	LG. Pistol Case, Plastic	2 Ea (1 ea)	100-Small Fab -	
20625A914	Dial Indicator Attchmnt Agd-2 Dial	2 Ea (1 ea)	100-Small Fab -	5217103
5416K41	SS Hose Clamp 3.5" Dia.	2 Ea (1 ea)	100-Small Fab -	5131311
90108A417	Flat Washer 3/8" Plated	4 Ea (2 ea)	100-Small Fab -	5044125
91259A583	Shoulder Screw 5/16" Shoulder Dia, 1" L Shoulder, 1/4"-20 Thread	2 Ea (1 ea)	100-Small Fab -	5044121
92845A245	18-8 Ss Extended (Dog) Point Socket Set Screw 10-24 Thread, 1/2" Length	4 Ea (2 ea)	100-Small Fab -	5131313
93839A815	Hex Nut 3/8-24 Unf	4 Ea (2 ea)	100-Small Fab -	5044124
97135A210	Nylon Lock Nut, 1/4-20	2 Ea (1 ea)	100-Small Fab -	5044120
98404A250	Quick Release Pin, Ø5/16 X 1	2 Ea (1 ea)	100-Small Fab -	5175979
98404A959	Quick Release Pin, Ø1/4 X 1	2 Ea (1 ea)	100-Small Fab -	5175981
AGD-2	1" Dial Indicator 0" to 1" Range	2 Ea (1 ea)	100-Small Fab -	5223690
RBT18520-1	Lift Device Frame	2 pcs (1 ea)	100-Small Fab -	1X5223303 1X5131310
RBT18520-11A	Weight Assembly	2 pcs (1 ea)	100-Small Fab -	5223303 5223387
RBT18520-15	Clevis Bracket	2 pcs (1 ea)	100-Small Fab -	5219239
RBT18520-16	Indicator Bracket	2 pcs (1 ea)	100-Small Fab -	5206724
RBT18520-5	Weldment	2 pcs (1 ea)	100-Small Fab -	5194308
RBT18520-7	Pivot Bar Weldment	2 pcs (1 ea)	100-Small Fab -	5194494
RBT18520-9A	Extension Assembly	4 pcs (2 ea)	100-Small Fab -	2X5111889 2X5220612

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	10164	2	1	0
	20625A914	2	3	0
	5416K41	2	13	0
	90108A417	4	78	0
	91259A583	2	6	0
	92845A245	4	11	0
	93839A815	4	37	0
	97135A210	2	23	0
	98404A250	2	8	0
	98404A959	2	0	0
	AGD-2	2	1	0
	RBT18520-1	2	4	0
	RBT18520-11A	2	3	0
	RBT18520-15	2	3	0
	RBT18520-16	2	3	0
	RBT18520-5	2	3	0
	RBT18520-7	2	3	0
	RBT18520-9A	4	3	0

Part Specifications

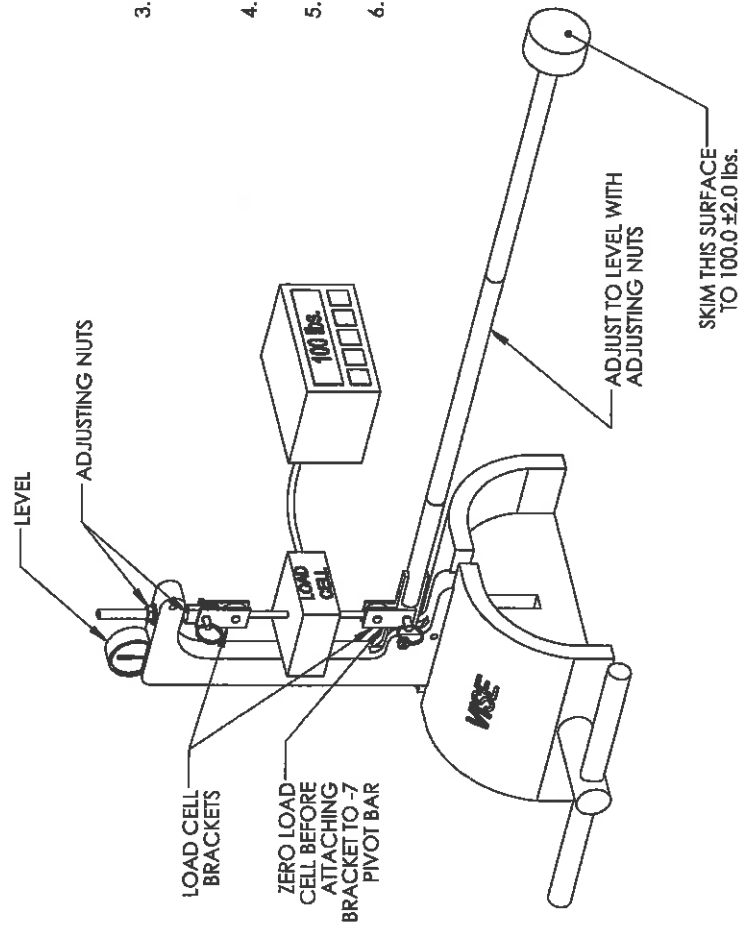
Specifications could not be found.

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TESTING PROCEDURES:

1. CLAMP UNIT IN VISE AS SHOWN, BE SURE UNIT IS LEVEL.
2. ATTACH THE LOAD CELL TO THE TOP ADJUSTING SCREW WITH BRACKETS AND SCREWS. MAKE SURE THAT THE LOAD CELL IS ALIGNED WITH THE ADJUSTING SCREW. ATTACH THE BOTTOM BRACKETS TO THE LOAD CELL, BUT DO NOT ATTACH THE BRACKETS TO THE -7 PIVOT BAR. PLUG THE LOAD CELL INTO THE DISPLAY AND PROPERLY PROGRAM THE DISPLAY. BE SURE TO ZERO THE LOAD CELL BEFORE CONTINUING.
3. ATTACH THE LOAD CELL BOTTOM BRACKETS WITH -14 PIN TO THE -7 PIVOT BAR. BE SURE THAT THE LOAD CELL IS ALIGNED WITH THE CENTER LINE OF UNIT.
4. ATTACH TWO -9A EXTENSIONS AND ONE -11A WEIGHT ASSEMBLY AS SHOWN.
5. LEVEL -9A EXTENSION ASSEMBLIES AND WEIGHT BY ADJUSTING THE TOP BOLT ADJUSTING NUTS.
6. SKIM THE FRONT FACE OF -11 BRASS WEIGHT UNTIL THE LOAD CELL REGISTERS 100.0 $\pm$ 2.0 lbs. THE -9A EXTENSION ASSEMBLIES MUST REMAIN LEVEL THROUGH THIS PROCESS. WHEN -11 HAS REACHED IT'S PROPER WEIGHT, THE UNIT IS CALIBRATED. BE SURE TO ENGRAVE THE PROPER INFORMATION ON THE -11 BRASS WEIGHT.



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TITLE			
M/R DAMPER LOAD TEST DEVICE			
DWG NO.	REV	DATE	WEIGHT TEST 1 OF 1
RBT18520	Q	8/17/2000	
SCALE	N/A	SHEET	15 OF 17



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____		DISPOSITION				DEPARTMENT/PROCESS																	
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐				Skid-tube ☐ Machining ☐ Large Fab ☐				Cross tube ☐ Small Fab ☐ Finishing ☐				Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐				Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)																			
Description Work Order Deviation		Disposition																					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY																					
		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____						Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐						Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐						Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
		Completed By _____																					
		Lead hand / Supervisor _____																					
		QC / QA Coordinator _____																					



Chicago Dial Indicator Co.
1372 Redeker Road
Des Plaines, IL 60016
ISO Registered Firm

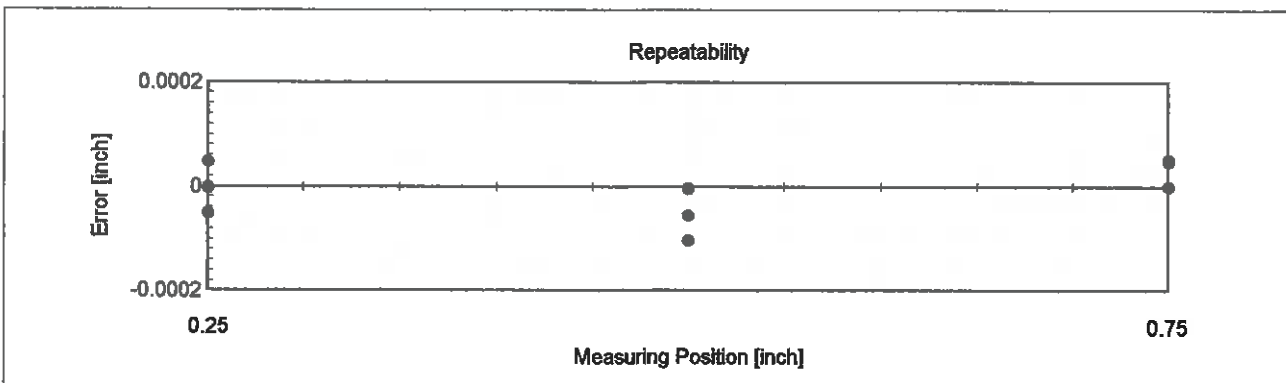
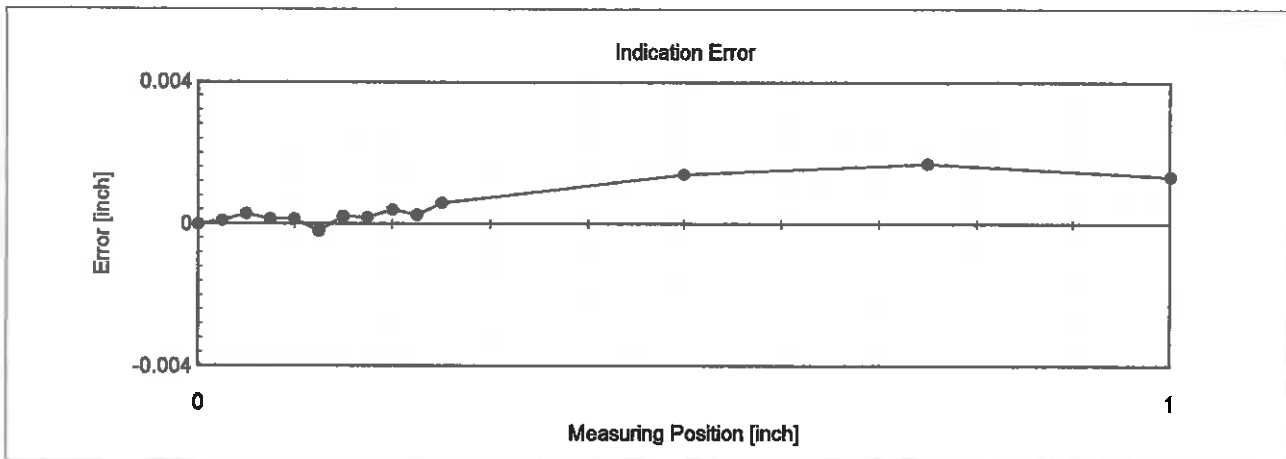
Factory Certificate of Calibration

Model No.	26104BJ-HC	Name of Inspection Standard	CDI Mechanical Standard
Serial No.	191010291	Unit	inch
Certificate No.	73136	Scale Interval	0.001 inch
		Measuring Range	1 inch
		Reference Point	0 inch
		End Point	1 inch

N.I.S.T. No. 821/268795-03

Inspection Item Name	Result	Permissible Value	Judgment
First 2-1/3 Revolutions	+0.0005875 inch	± 0.001 inch	GO
First 10 Revolutions	+0.0016865 inch	± 0.002 inch	GO
First 20 Revolutions	_____	_____	N/A
Hysteresis	_____	_____	N/A
Repeatability	-0.0001039 inch	± 0.0002 inch	GO

Inspection Item Name	Judgment
Inspection of Function and Appearance	GO



Repeatability is taken at three positions, with five readings at each position.

Phone: 847-827-7186
Fax: 847-827-0478
Website: www.dialindicator.com

Date _____
Put into service date, provided by end user

Signature: *Maria C*



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Des Plaines, IL 60016
ISO Registered Firm

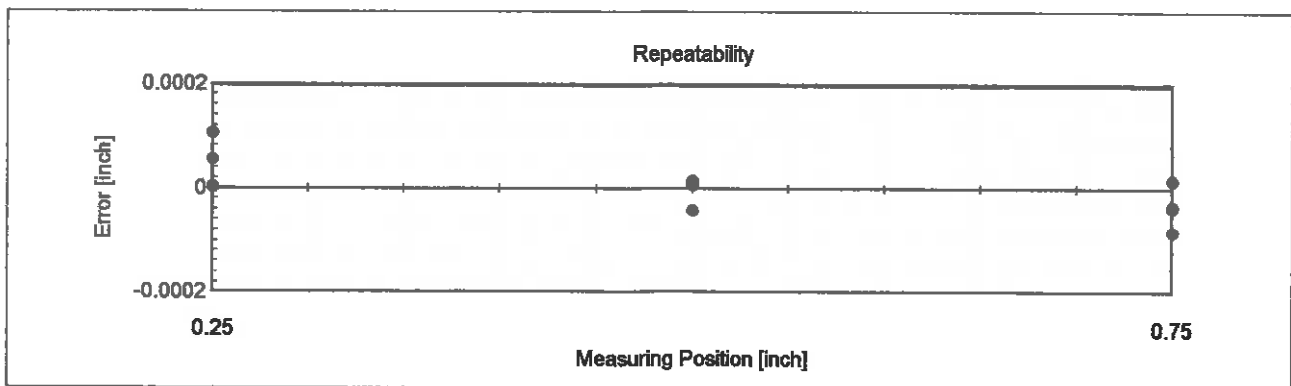
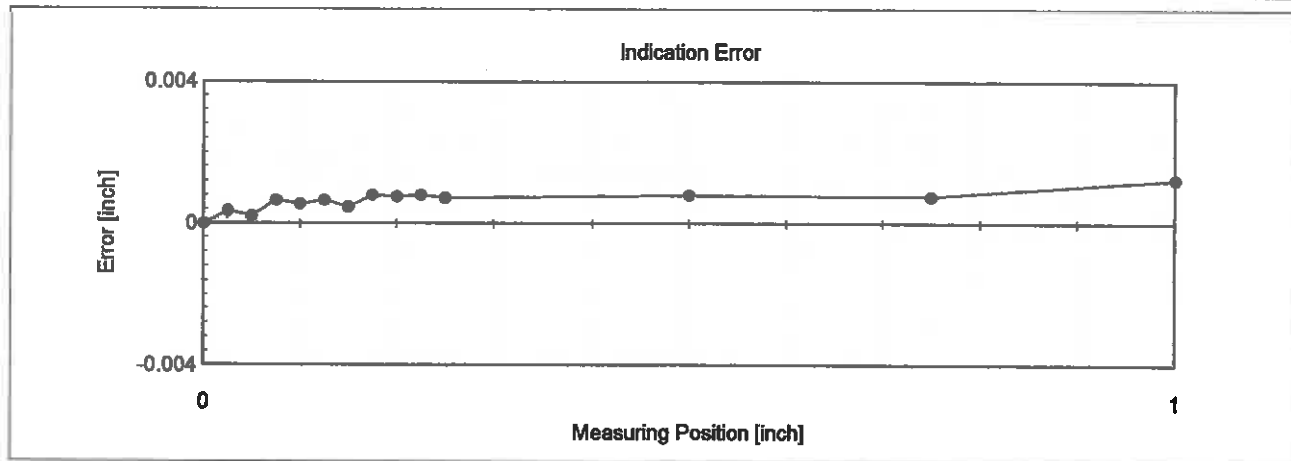
Factory Certificate of Calibration

Model No.	26104B	Name of Inspection Standard	CDI Mechanical Standard
Serial No.	182777555	Unit	inch
Certificate No.	70192	Scale Interval	0.001 inch
		Measuring Range	1 inch
		Reference Point	0 inch
		End Point	1 inch

N.I.S.T. No. 821/268795-03

Inspection Item Name	Result	Permissible Value	Judgment
First 2-1/3 Revolutions	+0.0008042 inch	± 0.001 inch	GO
First 10 Revolutions	+0.001255 inch	± 0.002 inch	GO
First 20 Revolutions			N/A
Hysteresis			N/A
Repeatability	+0.0001047 inch	± 0.0002 inch	GO

Inspection Item Name	Judgment
Inspection of Function and Appearance	GO



Repeatability is taken at three positions, with five readings at each position.

Phone: 847-827-7186
Fax: 847-827-0478
Website: www.dialindicator.com

Date _____
Put into service date, provided by end user

Signature: *[Handwritten Signature]*